

Amendment to the Claims:

The listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

Claim 1 (Withdrawn): A method for producing a container from a heated thermoplastic plastic film comprising clamping a segment of the plastic film by closing a molding tool comprising an upper tool part and a lower tool part having an inner surface generally corresponding to the shape of the container to be formed;

forming the container from the clamped portion of the plastic film by differential pressure;

buckling the container floor by upward axial movement of the molding tool floor to produce a standing base for the container;

pressing the buckled container floor, around its perimeter, against an inwardly directed pinched edge disposed on the inner surface of the lower tool part by upward axial movement of a sealing bell that surrounds the periphery of the molding tool floor to seal the base;

creating an empty cylindrical space between the inside surface of the container standing base and the outside surface of the mold floor by the retraction and lowering of the sealing bell without retraction of the molding tool floor; and

after opening of the molding tool, pushing the standing base beyond the pinched edge by axial movement of the molding tool floor, thereby causing the standing base to yield resiliently in the direction of the outside surface of the mold floor, to eject the container from the lower mold part.

Claim 2 (Currently amended): A molding tool for producing a container (9) having both a base (30) and pinched edge, leg, (31) from a heated thermoplastic plastic film (3) through deep drawing, the tool comprising,

an upper tool part (10) having a compressed-air supply;

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a lower tool part (11) having at least one blank punch (22) which has an axis and an interior surface and shaping parts, defining a cavity which has a perimeter and corresponds corresponding to the shape of the container (9) to be produced, wherein the interior surface has a shoulder (27) that extends inwardly around the perimeter and then continues in an enlarged diameter region (28), which enlargement region corresponds at least to the thickness of a wall (29) of the standing base (30), so that an undercut having a pinched edge (31) can be formed, disposed within the blank punch (22);

~~an inwardly directed pinched edge extending around the inner wall of the shaping part adjacent to its lower end and capable of cooperating with an adjacent surface to form a container leg;~~

an axially displaceable mold floor (33) for the lower tool part (11), which mold floor (33) receives a water flow via one or more bores (34) and connects to an axial displaceable rod (32) containing the bores (34), and the blank punch (22), and moveable between a first lowered position and a raised position above the pinched edge (31) by the axial displaceable rod (32);

an axially displaceable sealing bell (35), surrounding the periphery of the mold floor (33), and having the surface capable of cooperating with the shoulder (27) ~~pinched edge~~ when in a first raised position to form the container pinched edge, leg (31);

a drive in operational connection with the sealing bell (35) for separate displacement of the sealing bell (35) relative to the mold floor (33).

Claim 3 (Currently amended): A molding tool for producing a container (9) both a base and a pinched edge, leg, (31) from a heated thermoplastic plastic film (3) through deep drawing comprising,

an upper tool part (10) having a compressed-air supply;

a lower tool part (11) having at least one blank punch (22), which has an axis and an interior surface and shaping parts, defining a cavity which has a perimeter and corresponds corresponding to the shape of the container (9) to be produced, wherein the interior surface has a shoulder (27) that extends inwardly around the perimeter and then continues in an enlarged

diameter region (28), which enlargement region corresponds at least to the thickness of a wall (29) of the standing base (30), so that an undercut having a pinched edge (31) can be formed, disposed within the blank punch (22);

~~an inwardly directed pinched edge extending around the inner wall of the shaping part adjacent to its lower end and capable of cooperating with an adjacent surface to form a container leg;~~

an axially displaceable mold floor (33) for the lower tool part (11), which mold floor (33) connects to an axial displaceable rod (32), and the blank punch (22), and moveable between a first lowered position and a raised position above the shoulder ~~pinched edge (27)~~ by the axial displaceable rod (32);

an axially displaceable sealing bell (35) surrounding the periphery of the mold floor (33), and having the surface capable of cooperating with the shoulder (27)~~pinched edge~~ when in a first raised position to form the pinched edge, container leg (31); and

a drive in operational connection with the sealing bell (35) for separate displacement of the sealing bell (35) relative to the mold floor, wherein the mold floor (33) and the sealing bell (35) are guided axially relative to one another by a cylindrical fit of the floor (33) into the bell (35).

Claim 4 (Canceled)

Claim 5 (Currently amended): The molding tool according to claim 3 [[2]], wherein the drive acts on a retaining plate (38), with which all sealing bells (35) of a multicavity molding tool are connected, and the retaining plate (38) is connected to a piston (44) that is displaceable in a bore (47) in a plate connected to a base plate (20) for the lower part of the tool.

Claim 6 (Currently amended): The molding tool according to claim 3 [[2]], wherein the mold floor (33) is attached to a rod (32) that is connected to an ejector plate (45), which is connected to all the rods (32) of a multicavity molding tool, for selectively axially moving the mold floor (33).

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Claim 7 (Currently amended): The molding tool according to claim 6 wherein the rod (32) is rigidly connected to the ejector plate (45).

Claim 8 (Currently amended): The molding tool according to claim 6 wherein the rod (32) is rigidly connected to a carrier plate (52), to which all rods (32) of a molding cavity tools are connected, that is axially displaceable relative to the ejector plate (45).

Claim 9 (Currently amended): The molding tool according to claim 8, wherein the carrier plate (52) is connected to a piston (53) that is axially displaceable in a bore (54) in a shoulder (55) secured to the ejector plate (45).

Claim 10 (Currently amended): The molding tool according to claim 3 [[2]], wherein the shaping part comprises a mold insert (56) ~~having the pinched edge and~~ disposed within the blank punch that has a cutting edge (23).

Claim 11 (Currently amended): The molding tool according to claim 3 [[2]] wherein the blank punch (22) has a cutting edge (23) at its upper edge and the blank punch (22) and the shaping parts are integrally formed as one piece.

Claim 12 (Currently amended): The molding tool according to claim 3 [[2]], wherein the shaping parts comprise a mold insert (56) and a ring (43) having the pinched edge disposed within the blank punch having a cutting edge.

Claim 13 (Currently amended): The molding tool according to claim 12, wherein the ring (43) comprises hardened steel.

Claim 14 (Canceled)